

Ship Oct. 13-14

Work Order ID 137840

137840

Friday, October 09, 2015 12:37:02 PM

Page 1

Item ID: D407-836-017

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Stop ***NS2***

Start Date: 10/09/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: DA Date: 15-10-09 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-2	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D407-836-017 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MLS 15-10-13

DAS
02
9-89

OCT 13 2015

DAS
27
9-89

OCT 13 2015

DAS
02
9-89

DAS
02
9-89

OCT 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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137840

Page 2

Item ID: D407-836-017

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Stop ***NS2***Start Date: 10/09/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 02 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-836-017								
	Location: <u>GA 122</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

OCT 13 2015

MCS OCT 14 2015

MCS OCT 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 1

Work Order ID: 137840

137840

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 10/09/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1		Manufactured	No				Each	23.0000		1			
D4853-1	DAS								**		DAS		
Top Bracket (Replaces P/N G13013-1)	02										27		
	9-89										9-89		
				<u>Location</u>				<u>Loc Qty</u>					
				ST519				23					
					<u>135064</u>			23					
D4854-1		Manufactured	No				Each	8.0000		1			
D4854-1	DAS								**				
Lower Bracket (Replaces P/N G13013-2)	02											DAS	
	9-89										27		
				<u>Location</u>				<u>Loc Qty</u>				9-89	
				st526				8					
					<u>126502</u>			8					
D4855-1		Manufactured	No				Each	8.0000		1			
D4855-1	DAS								**				
Antenna Bracket (Replaces P/N G13013-3)	02											DAS	
	9-89										27		
				<u>Location</u>				<u>Loc Qty</u>				9-89	
				st526				8					
					<u>126143</u>			2					
					<u>128258</u>			6					

OCT 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Work Order ID: 137840

137840

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 10/09/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each

264.0000

2

D2732-030

Rubber Cushion - 3"

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

88

134608

32

135594

48

136784

8

ST410

176

136756

60

136784

116

Each

191.0000

2

AN4-16A

Purchased

No

AN4-16A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST325A

65

M133011

40

M133064

25

ST343

121

M132317

121

Each

152.0000

2

AN4-11A

Purchased

No

AN4-11A

BOLT

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST325A

132

M128362

32

M133234

100

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 137840

137840

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 10/09/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

Each

629.0000

8

NAS1149D0432J

WASHER

DAS
02
9-89

**

DAS

27
9-89

DAS

8
9-89

Location

Loc Qty

Loc Code

ST269

629

m131026

629

Each

1,201.000

4

MS21042L4

Purchased

No

MS21042L4

Locknut

DAS
02
9-89

**

DAS

27
9-89

DAS

8
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

107

m127813

107

ST260a

162

m130799

56

m131803

6

m132262

100

ST305

930

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

650

m133316

100

OCT 13 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT